

Date: Wednesday, 20/05/2009 11:32:09 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 48083		
Estimate Number	: 10564		
P.O. Number	:	Part Number	: D34433
This Issue	: 20/05/2009 S.O. No. :	Drawing Number	: D3443 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 46146	Material	:
Written By	:	Due Date	: 27/05/2009 Qty: 5 Um: Each
Checked & Approved By	: <u>MF 09-05-20</u>		
Comment	: Est Rev: A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304R1500	304 round bar 1.500
Comment: Qty.: 0.2500 f(s)/Unit Total : 1.2500 f(s) <u>SA 09/06/08 M106260</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA588 & DWG D3443 FOLIO REV: <u>15</u> DWG REV: <u>15</u> (5) 2-DEBURR AS REQUIRED <u>SA 09/05/23</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 09/05/23</u> (5)		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA588 Rev: <u>B</u> & Dwg D3443 Rev: <u>B</u> 2-Deburr per dwg D3443 <u>G.A 09/06/02</u> (5)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 48083

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(5)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA 09/06/02

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

SA 09/06/03 (5)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/06/05 (5)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MR 09/06/03 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *Cur*

9/6/4

SK
SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



MR
09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

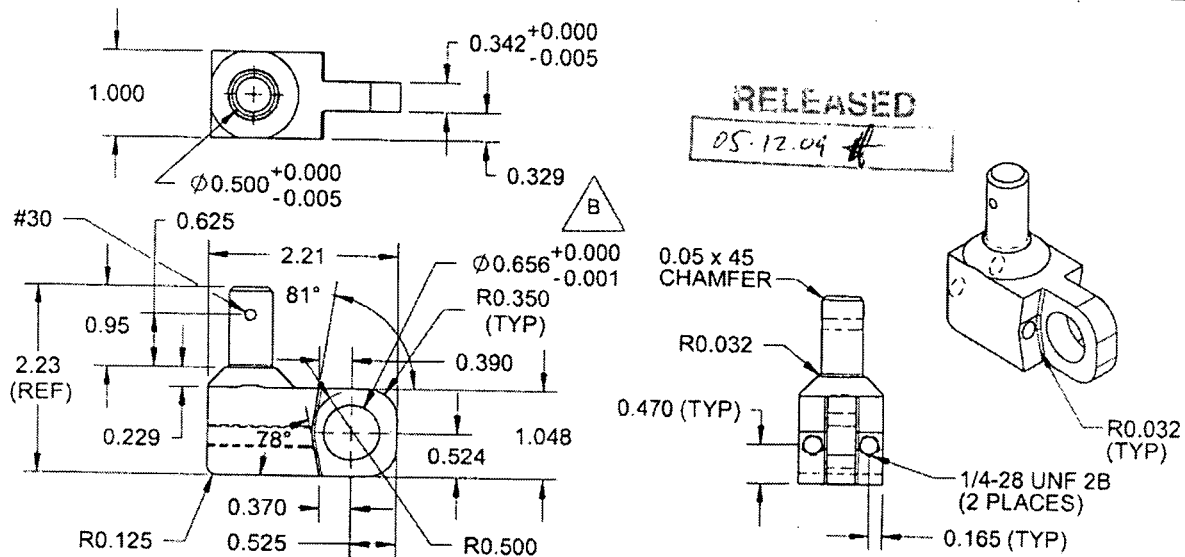
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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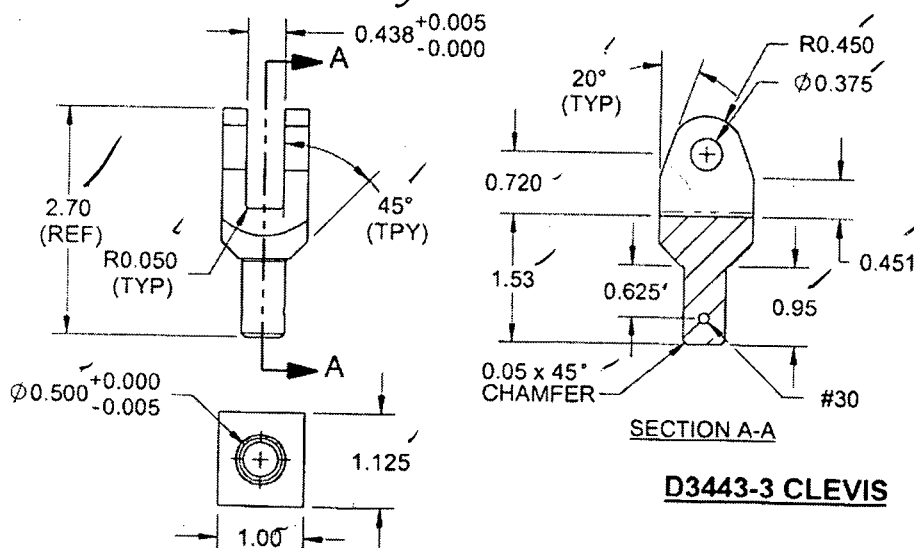
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2	



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- GENERAL NOTES:**
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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